



Ship Via:

DAS
15
)-89

Plex 2/7/19 9:05 AM Dart.Hadley.Shannon

					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	BEB19-02-08
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	2/12/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	21 FEB 08 2019
					QC 21 - SA - 53	

Part Op **100** - Weld per dwg A/R S.S. rod Batch: _____ 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
 Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to
 fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg
106 - Weld per dwg A/R S.S. rod Batch: _____ 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
 before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to
 fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg
110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O
125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder
 coat
135 - Pick Kit
140 - QC3- Inspect Part Finish
150 - Assemble as per dwg - Pick Kit
160 - QC5- Inspect part completeness to step on W/O
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

M138997 START: 3:25 TEMP: 400° FINISH: 3:55
 375°

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	90-Start up Operation	
D3913-1	Rib	1 pcs (1 ea)	90-Start up Operation	
D3913-15	Wide Handle Plate	1 pcs (1 ea)	90-Start up Operation	
D3913-3	Rib	1 pcs (1 ea)	90-Start up Operation	
D3913-7	Rib	2 pcs (2 ea)	90-Start up Operation	
D3913-9	Hinge Rib	1 pcs (1 ea)	90-Start up Operation	
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	
D3916-5	Light Rib	3 pcs (3 ea)	90-Start up Operation	
D4016-1	Hinge Half, Base	3 pcs (3 ea)	90-Start up Operation	
D4017-7	Rib	3 pcs (3 ea)	90-Start up Operation	
D4017-9	Rib	2 pcs (2 ea)	90-Start up Operation	
D4020-11	End Mesh, Basket	2 pcs (2 ea)	90-Start up Operation	
D4021-1	Handle Plate	3 pcs (3 ea)	90-Start up Operation	
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	90-Start up Operation	
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	90-Start up Operation	
D4672-1	Blanking Plate	2 pcs (2 ea)	90-Start up Operation	
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	
AN3-10A	Bolt	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	
NAS1149F0332P	Washer	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	
NAS1149FN832P	Washer	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	69	0
	D3913-1	1	4	0
	D3913-15	1	16	0
	D3913-3	1	4	0
	D3913-7	2	10	0
	D3913-9	1	9	0
	D3916-041	2	6	0
	D3916-5	3	21	0
	D4016-1	3	141	0
	D4017-7	3	28	0
	D4017-9	2	20	0
	D4020-11	2	28	0
	D4021-1	3	53	0
	D4034-041	1	3	0
	D4034-043	1	2	0
	D4672-1	2	34	0
	M304EX0.75-16F	33	1,934	0
	AN3-10A	6	223	0
	D2931	2	811	0
150-Handfinish - 4-1-Assembly-B4B	D4021-5	2	36	0
	MS20600-AD4W3	2	143	0
	MS21042L3	6	2,724	0
	NAS1149F0332P	12	3,030	0
	NAS1149FN832P	2	3,154	0

Part Specifications

Specifications could not be found.

Plex 2/7/19 9:05 AM Dart.Hadley.Shannon

Order 11943



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3913-041

Job Sheet 188900



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/16/19

Job Tracking No:

Due Date: 2/12/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/12/19	0.00	0.00	Start Up Large Fab-5		MFL
100	Large Fab	1 pcs		2/12/19	0.00	10.00	Large Fab 1		DAS
110	QC	1 pcs		2/12/19	0.00	0.00	QC9		24 cpc
120	QC	1 pcs		2/12/19	0.00	0.00	QC5		9-89 cpc
125	HandFinish	1 pcs		2/12/19	0.00	0.29	HandFinish2		
130	Powdercoat	1 pcs		2/12/19	0.00	0.93	Powdercoat2		
135	Packaging	1 pcs		2/12/19	0.00	0.00	Packaging1		
140	QC	1 pcs		2/12/19	0.00	0.00	QC3		
150	HandFinish	1 pcs		2/12/19	0.00	0.50	HandFinish4		
160	QC	1 pcs		2/12/19	0.00	0.00	QC5		
170	Packaging	1 pcs		2/12/19	0.00	0.00	Packaging3-2		
180	QC21-SA	1 Ea		2/12/19	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
 Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
 holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
 Weld D4672-1 blanking plates as per dwg
 130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
 150 - Pick Kit

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	90-Start up Operation	S 143 339
D3913-1	Rib	1 pcs (1 ea)	90-Start up Operation	S 141 494
D3913-15	Wide Handle Plate	1 pcs (1 ea)	90-Start up Operation	S 143 390
D3913-3	Rib	1 pcs (1 ea)	90-Start up Operation	S 145 057
D3913-7	Rib	2 pcs (2 ea)	90-Start up Operation	S 143 685
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	S 148 008
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	S 146 206
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	S 147 580
D4016-1	Hinge Half, Base	3 pcs (3 ea)	90-Start up Operation	S 115 309
D4017-7	Rib	3 pcs (3 ea)	90-Start up Operation	S 143 925
D4017-9	Rib	2 pcs (2 ea)	90-Start up Operation	S 145 188
D4020-11	End Mesh, Basket	2 pcs (2 ea)	90-Start up Operation	S 144 983
D4021-1	Handle Plate	3 pcs (3 ea)	90-Start up Operation	S 143 400
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	S 147 669
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	S 147 371
D4672-1	Blanking Plate	2 pcs (2 ea)	90-Start up Operation	S 145 300
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	S 125 258
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	S 132 304-1
D2931	Bumper	2 pcs (2 ea)	150-HandFinish	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	S 076007
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	S 094 592
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	S 134 693-1
D4021-5	Blanking Plate	2 pcs (2 ea)	150-HandFinish	S 144 379
NAS1149FN832P	Washer	2 Ea (2 ea)	150-HandFinish	S 136 368-1

M.4. 008018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	63	0
	D3913-1	1	5	0
	D3913-15	1	25	0
	D3913-3	1	9	0
	D3913-7	2	16	0
	D3913-9	1	4	0
	D3916-041	2	10	0
	D3916-5	3	19	0
	D4016-1	3	168	0
	D4017-7	3	35	0
	D4017-9	2	20	0
	D4020-11	2	19	0
	D4021-1	3	50	0
	D4034-041	1	8	0
	D4034-043	1	7	0
	D4672-1	2	2	0
	M304EX0.75-16F	33	1,308	0
150-HandFinish	AN3-10A	6	201	0
	D2931	2	829	0
	D4021-5	2	32	0
	MS20600-AD4W3	2	193	0
	MS21042L3	6	2,251	0
		12	2,259	0
		2	3,361	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S150752



Part: D3913-041

Job No: 188900

Serial No/Batch: S150752

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/05/19

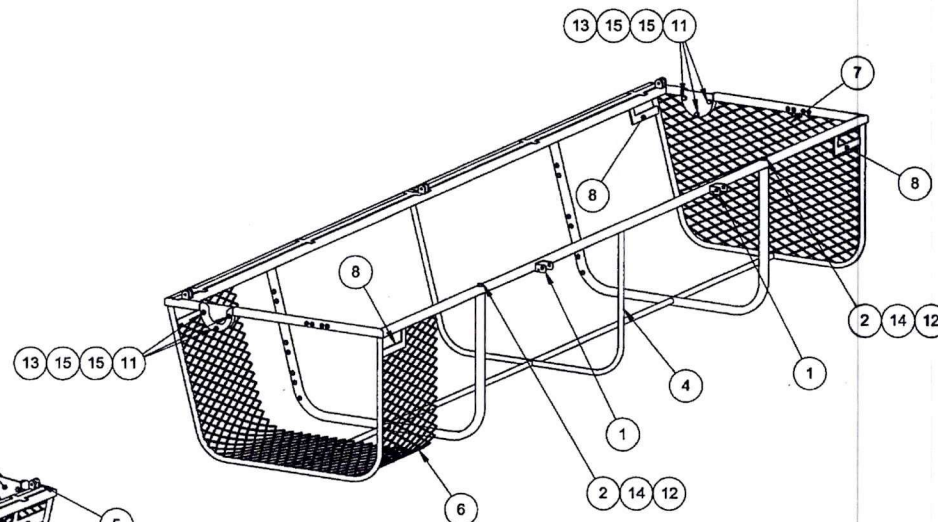
ions

it be found.

Plex 1/16/19 12:57 PM Dart.Macdonald.Dara

007907

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	MS20600AD4W3	RIVET, BLIND
13	6	MS21042L3	NUT, SELF-LOCKING
14	2	NAS1149FN832P	WASHER
15	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004
- 11) MASK THIS AREA PRIOR TO FINISH

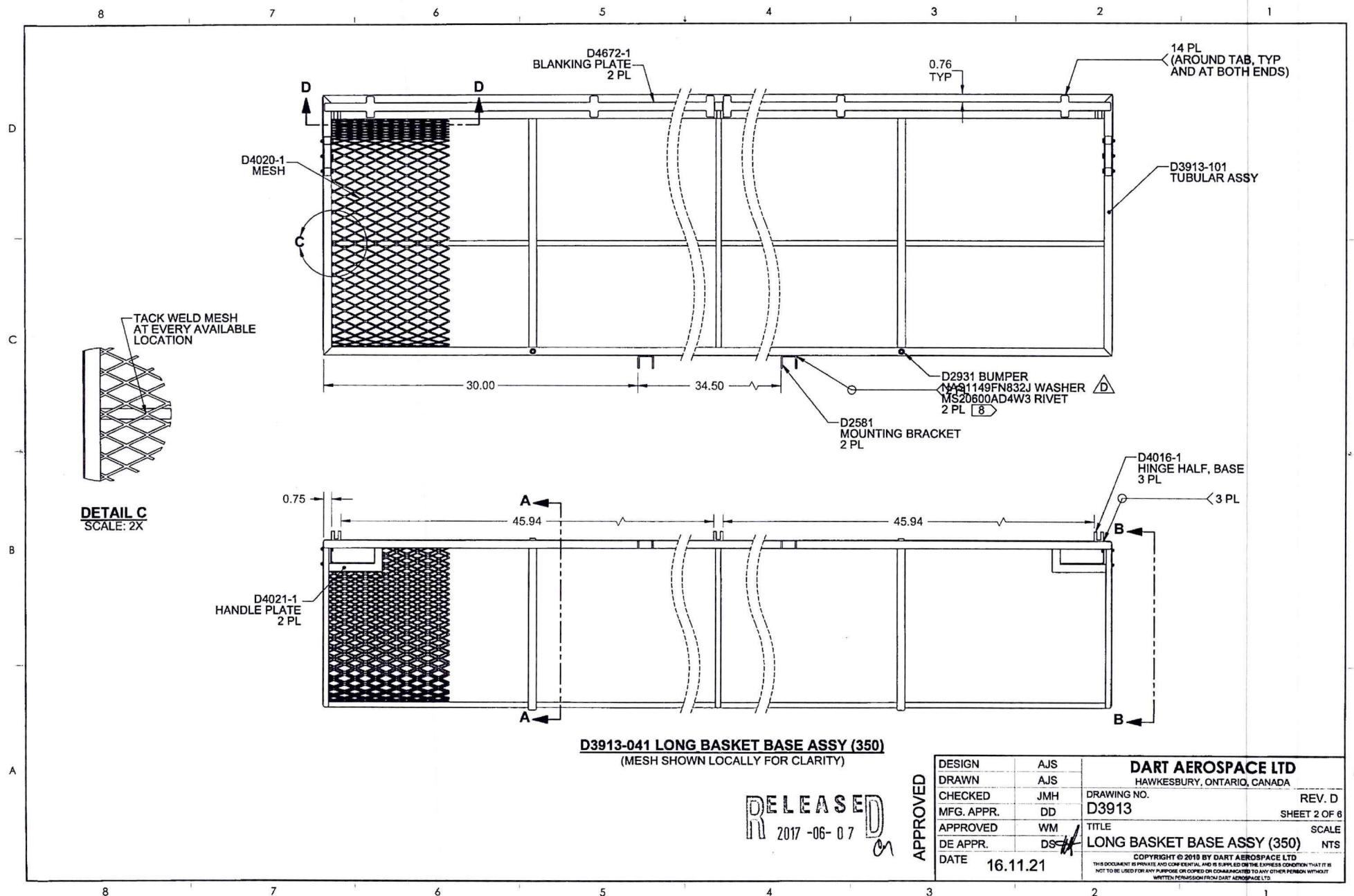
RELEASED
2017-06-07
601 17-580

D	ALL DETAIL/SECTION VIEW LETTERS UPDATED. SHEET 1: ITEM 14 WAS AN980JD8, UPDATED NOTE 6, ADDED NOTE 11. SHEET 3 ADDED VIEW E-E. (PAR15-418)	AJS	16.11.21
C	PICTORIAL UPDATES TO MULTIPLE SHEETS FOR CHANGES TO D4034-043 (REASON REMOVAL OF PROP ARM OPTION). D5-4 ADDED 2 MORE D4017-7 RIBS TO PREVENT BOWING. MULTIPLE DIMENSIONS RE-TOLERANCED FOR EASE OF MANUFACTURE. SECTION F-F & G-G ADDED.	AJS	13.07.18
B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PAR12-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	JMH		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	D9		
DATE	16.11.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. D
SHEET 1 OF 6
TITLE **LONG BASKET BASE ASSY (350)** SCALE NTS

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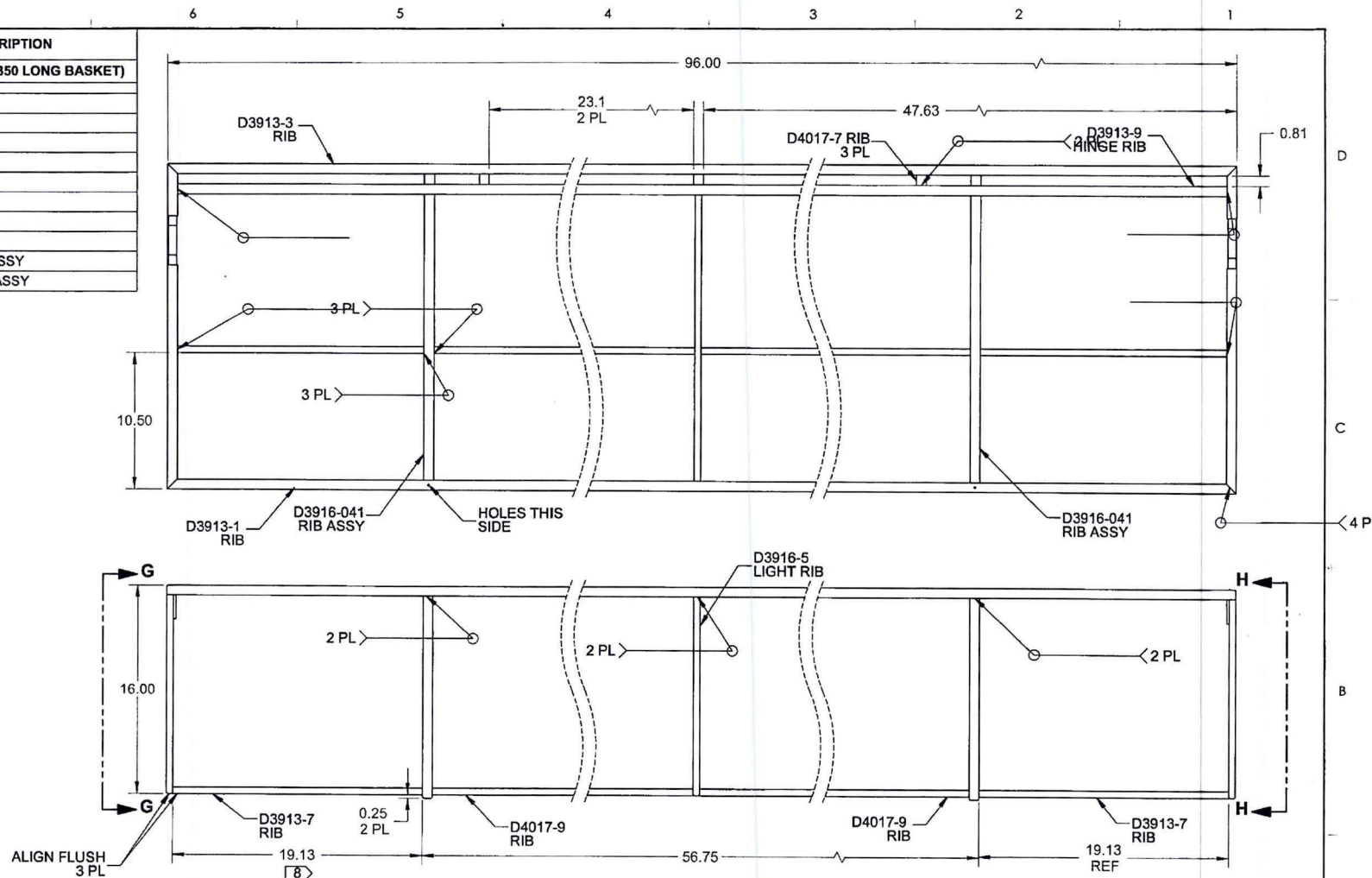
RELEASED
2017-06-07

APPROVED

DESIGN	AJS
DRAWN	AJS
CHECKED	JMH
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	16.11.21

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3913	REV. D SHEET 2 OF 6
TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	3	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



D3913-101 TUBULAR ASSY (350 LONG BASKET)

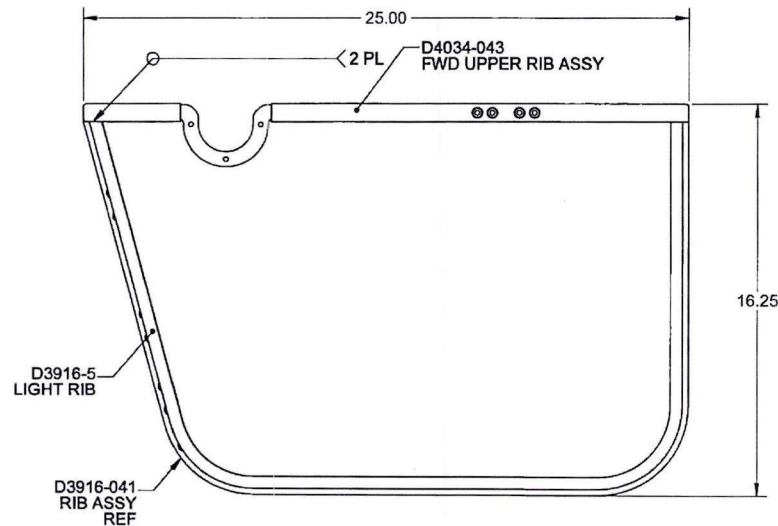
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.65 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

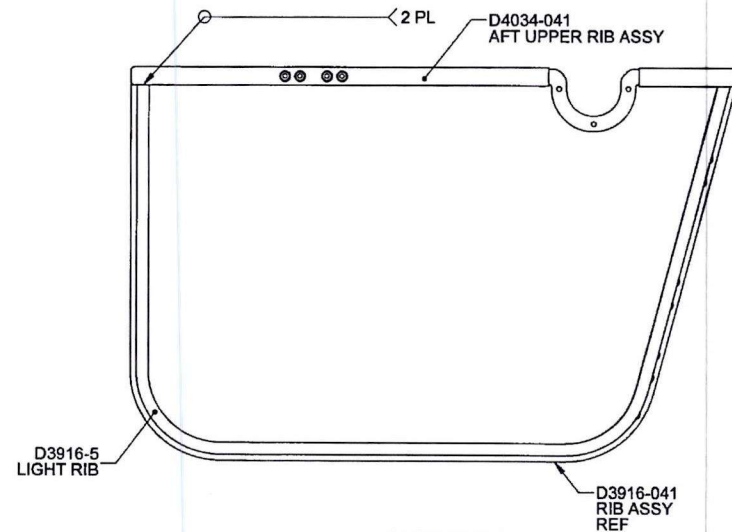
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2017-06-07

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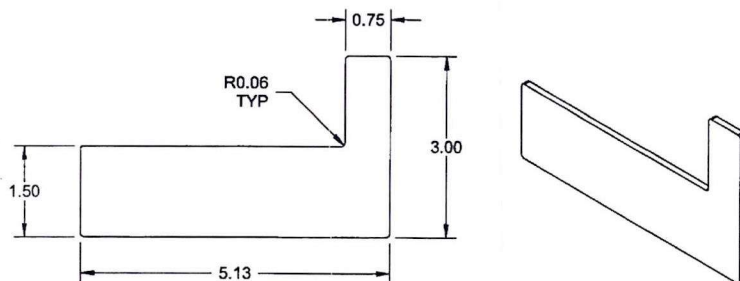
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3913	SHEET 4 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET BASE ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION G-G
SCALE 2X



SECTION H-H
SCALE 2X



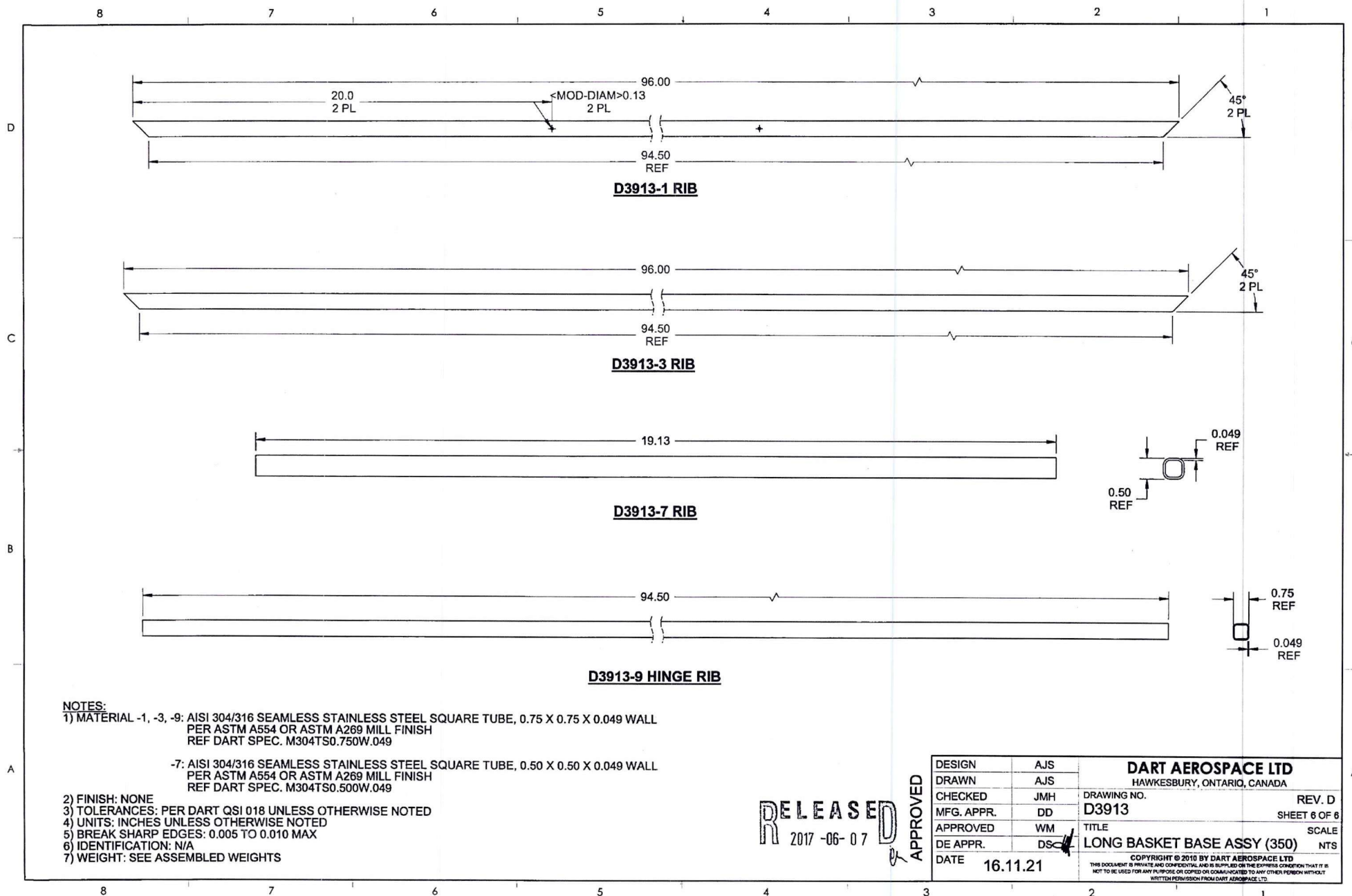
D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.125 THICK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2017-06-07
APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3913	SHEET 5 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET BASE ASSY (350)	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					